

Date: Monday, 12/19/2005 11:12:15 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET ASSEMBLY	
Job Number	25284			Part Number	: D3152041	
Estimate Number	11517			Drawing Number	: D3152 REV B	
P.O. Number	N/A			Project Number	: N/A	
This Issue	12/19/2005	S.O. No.	:	Drawing Revision	: B	
Prsh Rev.	NC			Material	: N/A	
First Issue	H/A	Type	SMALL /MED FAB	Due Date	: 12/23/2005	
Previous Run	:			Qty:	12	
Written By	See comment below			Um:	Each	
Checked & Approved By	See comment below					
Comment	Est Rev:B Removed Purchasing 05-12-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D31523	Seal			
		 <i>12</i>			
Comment: Qty.: 1.0000 Each(s)/Unit Total : <u>10.0000</u> Each(s) Pick: Qty Part # Description Batch: <u>5 = m 13/59</u> <u>1 D3152-3 Seal</u> <u>7 = m 10536-17</u>					
2.0	D31521	Bracket			
		 <i>ml 05/12/19</i>			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part # Description Batch: <u>(12) B18867</u>					
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
		 <i>ml 05/12/19</i>			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Bond D3152-3 Seal to D3152-1 Bracket using RTV 732 per Dwg D3152. RTV 732 Black Batch: <u>M 16368</u> Expiry: <u>17 Feb 2007</u>					
Identify as D3152-041  <i>ml 05/12/19</i>					
4.0	QC5	INSPECT WORK TO CURRENT STEP			
		 <i>Job 01-16</i>			
Comment: INSPECT WORK TO CURRENT STEP					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p> <p><i>Marked</i> <i>6/1/18</i> <i>(12)</i></p>		
6.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL <i>6/18/18</i> <i>(12)</i> <i>DD</i> <i>6/18/18</i></p>		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

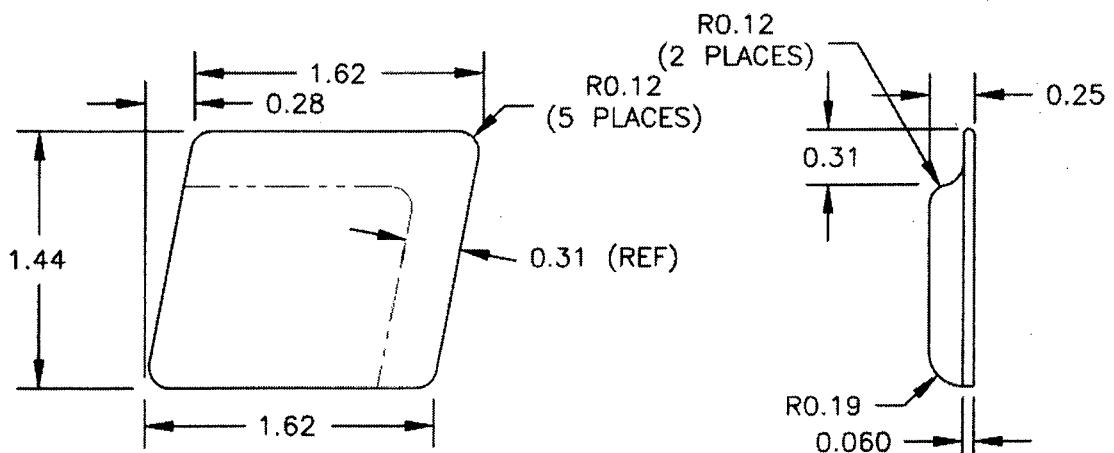
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		D3152	REV. B
DATE		TITLE	SCALE
04.10.18		BRACKET ASSEMBLY	1:1
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING & RTV 732 BLACK	

RELEASED
04.11.23**D3152-041 BRACKET ASSEMBLY**
D3152-042 BRACKET ASSEMBLYIDENTIFY WITH DART P/N
USING FINE POINT PERMANENT
INK MARKERD3152-3 (-041)
or D3152-4 (-042)BOND D3152-3/-4(OPP) SEAL TO
D3152-1/-2(OPP) BRKT USING
RTV 732 CLEAR (A/R)
OR RTV 732 BLACK (A/R)D3152-1 (-041)
or D3152-2 (-042)**D3152-3 SEAL (SHOWN)**
D3152-4 SEAL (OPPOSITE)

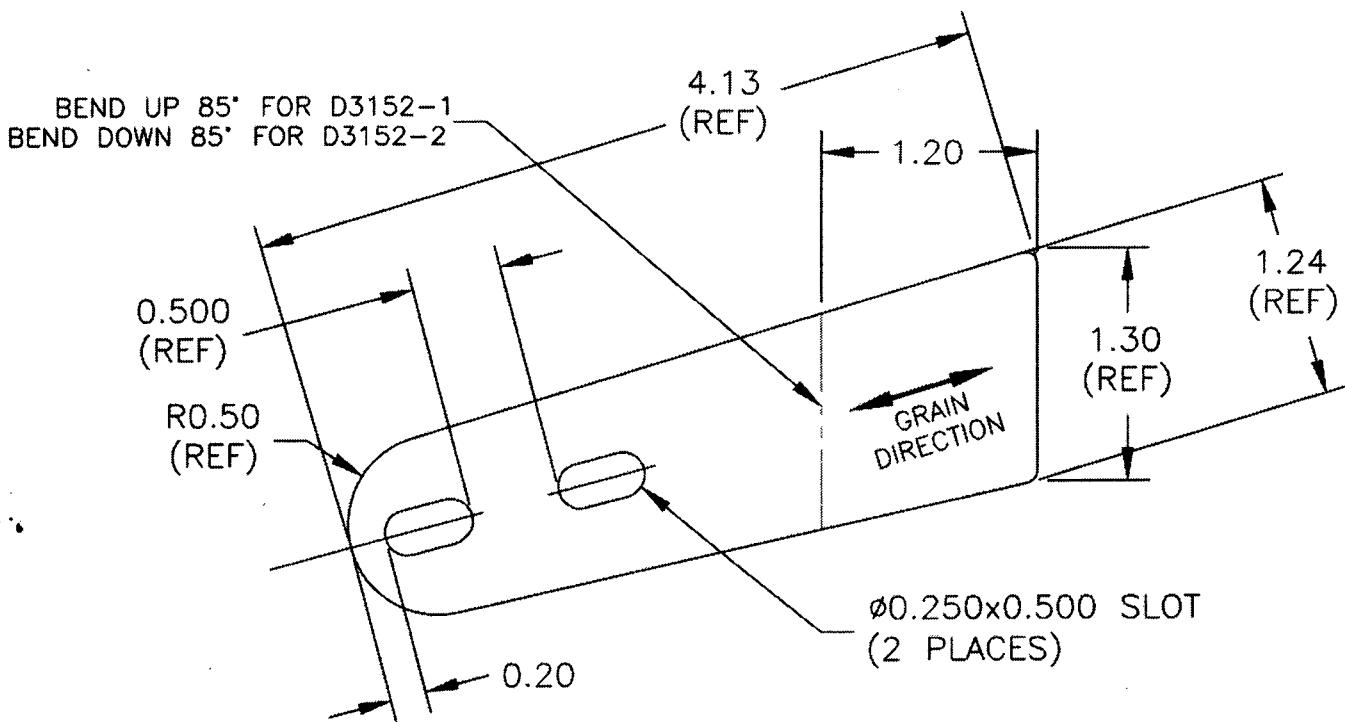
1. D3152-3 REPLACES PREMIER P/N B30-23000-243
2. D3152-4 REPLACES PREMIER P/N B30-23000-244
3. MAKE D3152-3 PER TOOL # B30-23000-243T
4. MAKE D3152-4 PER TOOL # B30-23000-244T
5. MATERIAL: RTV 732 BLACK
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7. ALL DIMENSIONS ARE IN INCHES



1 COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	04.10.18	TITLE	SCALE SHEET 2 OF 2 1:1

RELEASED
04.11.23



D3152-1/-2 BRACKET

1. D3152-1 REPLACES PREMIER P/N B30-23000-223
2. D3152-2 REPLACES PREMIER P/N B30-23000-224
3. MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF DART SPEC. M2024T3S.063)
4. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6. ALL DIMENSIONS ARE IN INCHES
7. BREAK ALL SHARP EDGES 0.005 TO 0.010
8. MACHINE PER DWG FILE "D3152-B2.DWG"